



Dart Aerospace Ltd.
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Canada

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D3393-1

Job Sheet 208753



Part No: D3393-1

Job Qty: 10 pcs

Part Name: Battery Lock Casing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/31/20

Job Tracking No:

Due Date: 4/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.02.18 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		4/29/20	0.00 0.02	Bandsaw - 1		Kt 20/04/04
110	HAAS 4 Axis - B4B	10 pcs		4/29/20	0.33 5.13	HAAS - 1 - B4B W-5000-2-B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B		Kt 20/04/05
130	QC 8	10 pcs		4/29/20	0.00 0.00	QC 8 - 12 QC 8 - 14 QC 8 - 17 QC 8 - 20 QC 8 - 25 QC 8 - 3 QC 8 - 32 QC 8 - 33 QC 8 - 35 QC 8 - 39 QC 8 - 4 QC 8 - 44 QC 8 - 45 QC 8 - 49 QC 8 - 58 QC 8 - 8 QC 8 - 9 QC 8 - 68 QC 8 - 67 QC 8 - 1 (A) QC 8 - 47 QC 8 - 40 QC 8 - 52 QC 8 - 23 QC 8 - 57		St 20-04-05



Container No: S268791



Part: D3393 - 1

Job No: 208753

Serial No/Batch: S268791

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 04/04/20

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					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	4/29/20	0.00 0.30	Handfinish - 1 - 1 - B4B		BFB20-04-08
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150 Powdercoat - 6 Fire Red - B4B	10 pcs	4/30/20	0.00 0.37	Powdercoat - 1 - B4B		
M 22542				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		20-11-8
START 11:15 OUT 3:20 FTWISH 11:45				Powdercoat - 4 - B4B		
160 QC 3	10 pcs	4/30/20	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		

					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
170 Packaging 3-1 - Stock - B4B	10 pcs	4/30/20	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B	DAS	
				Packaging 3 - 6 - B4B	28	
				Packaging 3 - 7 - B4B	9-89	
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
180 QC 21 - SA	10 pcs	4/30/20	0.00 0.00	QC 21 - SA - 21	DAS	
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	9-89	

APR 09 2020

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Part Op 100 - (Bandsaw) Cut blank: 1.500" x 1.500" x 3.125" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3) START TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X1.500	6061-T6 Bar 1.50 X 1.50	2.7080 ft (.2708 ea)	100-Bandsaw - 1	S033413 = 0.520 S017526 = 1.822 S225344 = 0.2708

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X1.500	3	27	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type Special Comments
1	Battery Lock Casing	0.750Inches $\pm$ 0.010	0.760 0.740	Diameter 0.751
2	Battery Lock Casing	0.625Inches $\pm$ 0.010	0.635 0.615	0.627
3	Battery Lock Casing	1.250Inches $\pm$ 0.010	1.260 1.240	Diameter 1.250
4	Battery Lock Casing	1.088Inches $\pm$ 0.010	1.098 1.078	1.088.
5	Battery Lock Casing	0.734Inches $\pm$ 0.010	0.744 0.724	Diameter 0.740
6	Battery Lock Casing	2.658Inches $\pm$ 0.010	2.668 2.648	2.658
7	Battery Lock Casing	1.550Inches $\pm$ 0.010	1.560 1.540	1.550.
8	Battery Lock Casing	0.125Inches $\pm$ 0.010	0.135 0.115	0.125
9	Battery Lock Casing	45.000Degrees $\pm$ 5.000	50.000 40.000	Angle 45°
10	Battery Lock Casing	1.500Inches $\pm$ 0.030	1.530 1.470	1.500
11	Battery Lock Casing	0.750Inches $\pm$ 0.010	0.760 0.740	0.750
12	Battery Lock Casing	1.050Inches $\pm$ 0.010	1.060 1.040	Diameter 1.050
13	Battery Lock Casing	1.000Inches $\pm$ 0.010	1.010 0.990	Diameter 1.001
14	Battery Lock Casing	0.338Inches $\pm$ 0.010	0.348 0.328	0.335
15	Battery Lock Casing	0.563Inches $\pm$ 0.010	0.573 0.553	0.565
16	Battery Lock Casing	0.100Inches $\pm$ 0.000 - 0.010	0.100 0.090	0.100 0.099.
17	Battery Lock Casing	3.000Inches $\pm$ 0.030	3.030 2.970	3.000
18	Battery Lock Casing	1.500Inches $\pm$ 0.010	1.510 1.490	1.500
19	Battery Lock Casing	0.375Inches $\pm$ 0.010	0.385 0.365	0.375
20	Battery Lock Casing	1.250Inches $\pm$ 0.030	1.280 1.220	1.250
21	Battery Lock Casing	0.125Inches $\pm$ 0.010	0.135 0.115	0.125
22	Battery Lock Casing	30.000Degrees $\pm$ 0.500	30.500 29.500	Angle 30°

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					